

12

Date: Tuesday, 3/11/2008 1:17:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARING OVERHAUL KIT
Job Number : 37817	
Estimate Number : 12398	
P.O. Number :	Part Number : D412698019
This Issue : 3/11/2008 S.O. No. :	Drawing Number : IIN D412-698 REVD
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 34808	Material :
Written By : <u> </u>	Due Date : 3/18/2008 Qty: 2 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:B 05-10-12 Pick List Revised KJ/JLM	
Est Rev:C 08-01-28 change to rev D ECN 1104 DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: Photocopy bluefile & type labels per PPPD412-698-019	CHG001
---	--------

09/04/21 08/03/14

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

3.0	D312121	Bolt
-----	---------	------



Comment: Qty.: 7.0000 Each(s)/Unit	Total : 14.0000 Each(s)
------------------------------------	-------------------------

Bolt

Batch:

B37879

AS 08/04/21 (X2)

4.0	D3121241	Bearing Assembly
-----	----------	------------------



Comment: Qty.: 5.0000 Each(s)/Unit	Total : 10.0000 Each(s)
------------------------------------	-------------------------

Bearing Assembly

Batch:

B37750

AS 08/04/21 (X2)

5.0	D31373	Guide
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit	Total : 2.0000 Each(s)
------------------------------------	------------------------

Guide

Batch:

B37657

AS 08/04/21 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING OVERHAUL KIT

Job Number: 37817

Part Number: D412698019

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31375

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: B37881

AS 08/04/21 (X)

7.0

D3183045

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bearing Assembly

Batch: 38104

AS 08/04/21 (X)

8.0

MS24694S101

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch: M163338

AS 08/04/21 (X)

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/21 (X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-019

Location: A

PPP Rev: A

8/4/21 scf

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/23

Job Completion



mf 08-04-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Part Number	Description
X							D412-698-011	CABIN DOOR ROLLER KIT, LH
	X						D412-698-012	CABIN DOOR ROLLER KIT, RH
		X					D412-698-013	DOOR HANDLE KIT
			X				D412-698-015	DOOR SUPPORT KIT
				X			D412-698-017	REPLACEMENT DOOR TRACK KIT
					X		D412-698-019	BEARING OVERHAUL KIT
						X	D412-698-021	REPLACEMENT SHIM KIT
					7		D3121-21	BOLT
					5		D3121-241	BEARING ASSEMBLY
3	3						D3121-141	BRACKET ASSEMBLY
1							D3121-143	BRACKET ASSEMBLY
	1						D3121-144	BRACKET ASSEMBLY
					1		D3137-3	GUIDE
					1		D3137-5	WASHER
1	1						D3137-043	BRACKET ASSEMBLY
					2		D3183-045	BEARING ASSEMBLY
1							D3183-043	BRACKET ASSEMBLY
	1						D3183-044	BRACKET ASSEMBLY
9	9			9			D3199-1	BRACKET
1	1			1			D3202-1	COVER
		4					D3203-1	HANDLE
		1					D3220-041	DOUBLER
		1					D3220-042	DOUBLER
		2					D3220-3	DOUBLER
			2				D3200-1	DOOR POST BLOCK
			2				D3200-3	DOOR WEDGE
			2				D3201-1	DOUBLER
			1				D3201-3	ANGLE
			1				D3201-4	ANGLE
						3	D3238-1	SHIM
						1	D3238-3	SHIM
						2	D3238-5	SHIM
						6	D3238-11	SHIM
						2	D3238-13	SHIM
						4	D3238-15	SHIM
			12				AN960JD10L	WASHER
		8					AN960JD416L	WASHER
			12				MS21042L3	NUT (OR MS21042-3)
		8					MS21042L4	NUT (OR MS21042-4)
		16					MS24694-S98	SCREW
					1		MS24694-S101	SCREW
			12				MS24693-S277	SCREW

(CONTINUED ON PAGE 15)

• COPYRIGHT © 2003 BY DART AEROSPACE LTD •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: D

Date: 07.07.03

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 37817